

Work Order ID 59927

Thursday, June 17, 2010 10:40:10 AM



Page 1

Item ID: D3929-041

Accept



Setup

Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 6/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-6-17

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

10-6-17

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

10-6-17

QC

Quality Control

Memo

0.00

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup

Start



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Item Name: Gusset Assembly

Start Date: 6/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S10617

140



Large Fab

Large Fab

Memo

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 111679

6

07.01.01

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10.01.01

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Work Order ID 59927

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Page 3

Item ID: D3929-041

Revision ID:

Item Name: Gusset Assembly

Start Date: 6/17/2010 Start Qty: 6.00

Required Date: 6/24/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Setup Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

S102101

Tool #

100

Plan
Code

100

Accept
Qty

100

Reject
Qty

0

Reject
Number

100

Inspec.
Stamp

100

170



Packaging

Packaging

Identify as per dwg & Stock Location: B/C

0.00

0.00

100

100

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

100

100

MF
10-7-01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 17, 2010 10:40:16 AM

Page 1

Work Order ID: 59927



Parent Item: D3929-041



Parent Item Name: Gusset Assembly

Start Date: 6/17/2010

Required Date: 6/24/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA



304/316 0.125 Sheet

Purchased

No

100

sf

146.8059

0.45

2.842105



B106-17

(6)

114488

Location

MAT

Loc Qty

146.8059

Loc Code

114488

114799

128

D3907-1



Manufactured

No

130

Each

18.0000

12

12

Glo.06.30

Bushing

Location

WA

Loc Qty

18

Loc Code

57937

18

BS91896 →

(4) → (12) → (8)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59927
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10-6-17	Date:	10/06/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.27	New Issue	P/O D3929-041/-042	KJ  

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

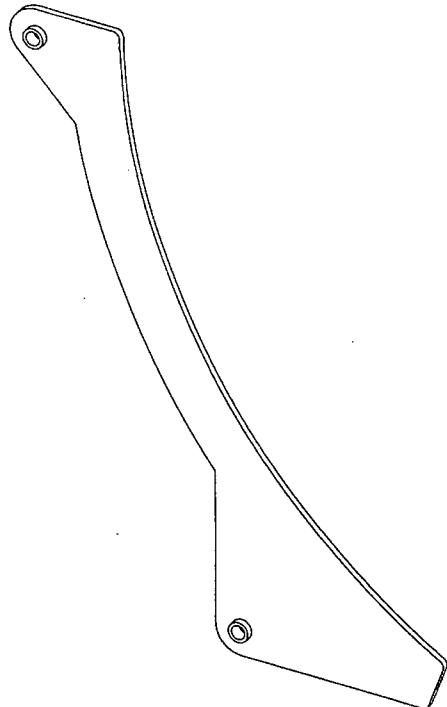
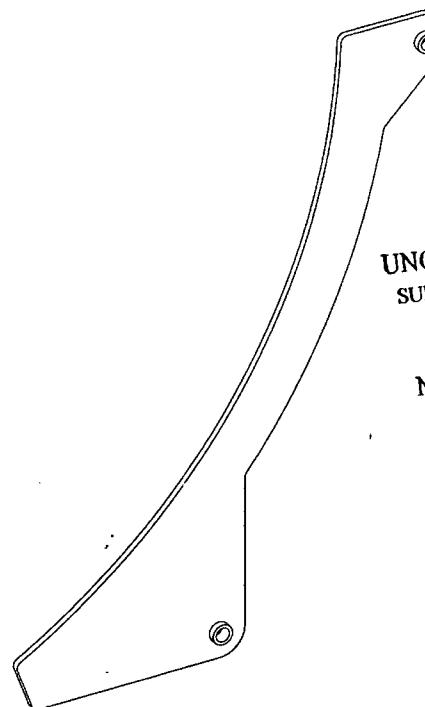
5

4

3

2

1

D3929-041 GUSSET ASSEMBLYD3929-042 GUSSET ASSEMBLY

D

C

B

A

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP DRAWING
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO ALL CHANGES
WITHOUT NOTICE
WORK ORDER

NO. 59927
PB10-6-17

RELEASED
07/04/12 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D3929	SHEET 1 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

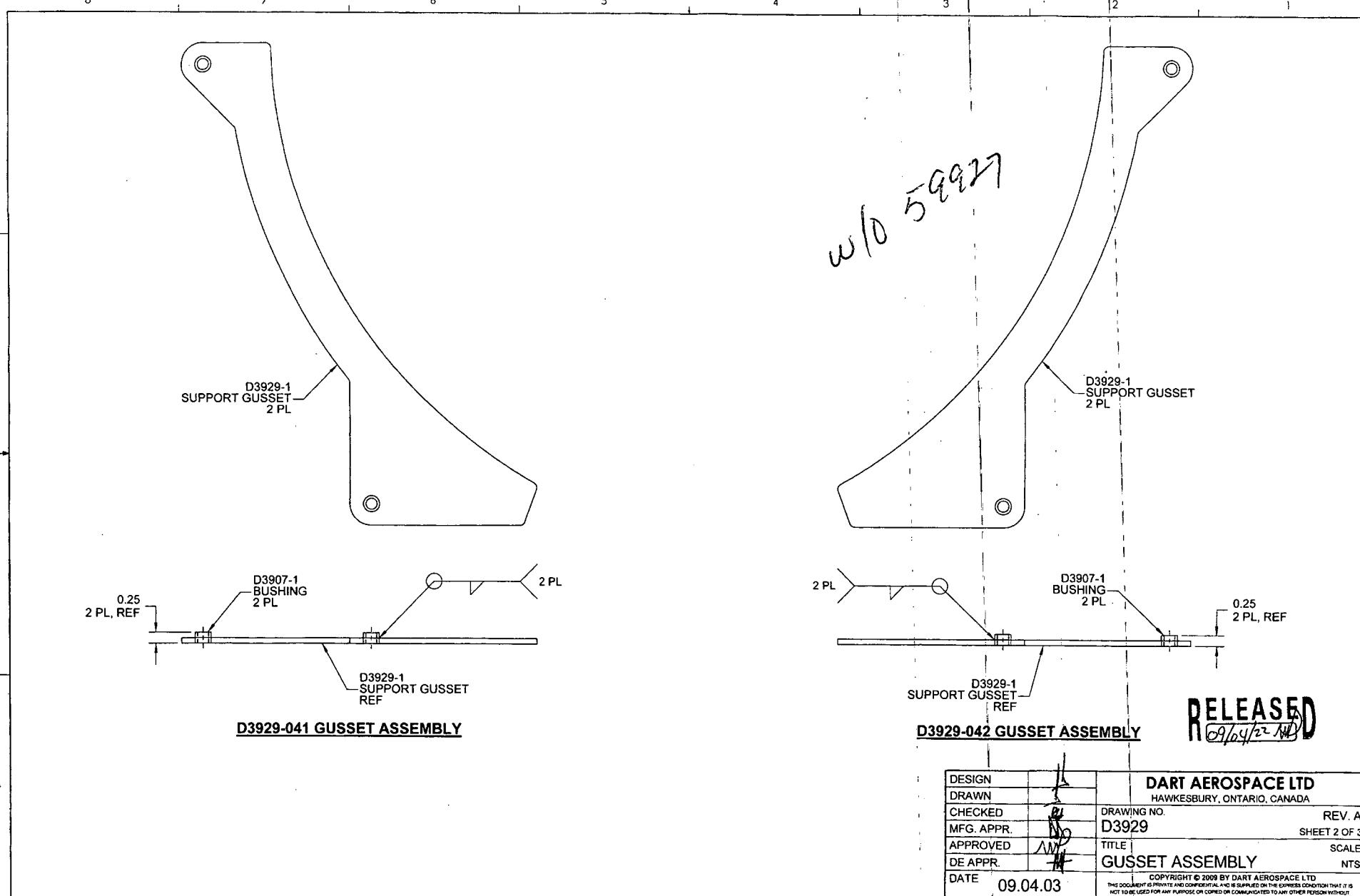
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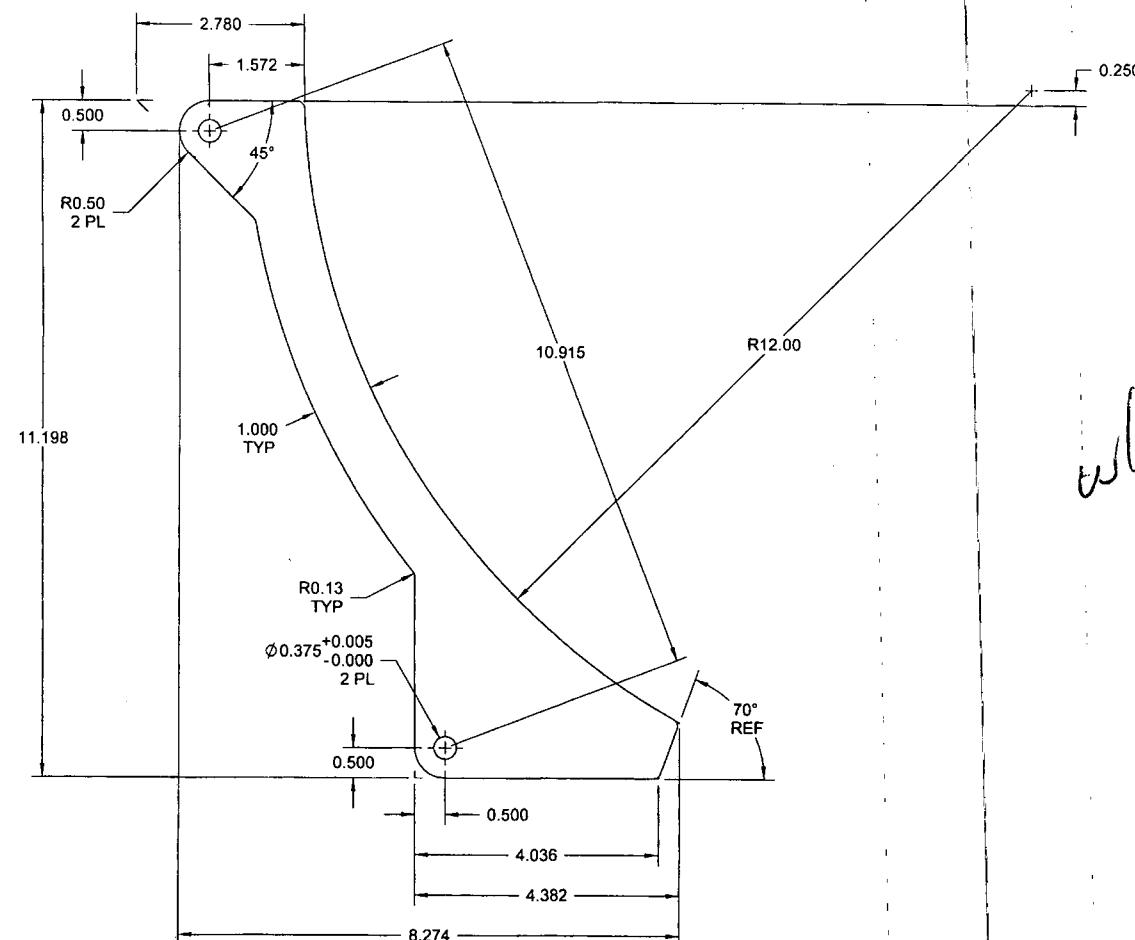
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D3929-1 SUPPORT GUSSET

A NOTES:

- 1) MATERIÁL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3929
APPROVED		REV. A
DE APPR.		SHEET 3 OF 3
DATE	09.04.03	TITLE
		GUSSET ASSEMBLY
		SCALE
		NTS

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RELEASED
(9/04/22 11:45)

Dart Aerospace Ltd

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